

Work Order ID 79209

January-23-12 2:00:48 PM

79209

Page 1

Item ID: D2662-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH In 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number. Inspect part number and batch number are programmed								
	MACHINE AS PER FOLIO FB069 & DWG DWG REV: <u>E</u> FOLIO REV: <u>AA</u>								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

B.A 12/02/13
FK- 12/02/14

OK / FK- 12/02/14

10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00				10	✓		
Quality Control									

130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				10	9		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

10X Ø M / 12/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

150
Powdercoat
Powder Coating
Memo
START TIME: 3:50
FINISH TIME: 4:20
OVEN TEMPERATURE:
W119480
3200F
10X2 M-L 12/02/16

160	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

160
QC
Quality Control
Memo
10 12 2 17

170	Identify as per dwg & Stock Location: 434	0.00							
-----	---	------	--	--	--	--	--	--	--

170
Packaging
Packaging
Memo
12/2/12 (10)

W/O:		WORK ORDER CHANGES					
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Work Order ID 79209***79209***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 23/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control



M.C.S 12/02/17

ME
12-02-17

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-23-12 2:00:51 PM

Page 1

Work Order ID: 79209

79209

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	14.0000	1	10			

D6101-001

Saddle Billet

**

S.A 12/02/13

Location

Loc Qty

Loc Code

MAT040

14

69677

2

73774

11

76836

1

→ 78598

10.0

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DART AEROSPACE LTD		Work Order:	79209
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.127	.122	.122	.121	.121
G	0.210	0.230		.227	.224	.223	.223	.223
H	0.615	0.685		.680	.685	.685	.685	.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.330	1.326	1.326	1.325	1.324
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.188	.500
M	1.125	1.145		1.136	1.136	1.1357	1.1354	1.135
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145	.140	.140	.140	.140	.140	.140
P	0.240	0.260		.254	.251	.251	.250	.250
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.549	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.116	.117	.116	.117	.117
AE	0.235	0.240		.236	.236	.236	.236	.236
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.109	.109	.109	.109	.109
AH	1.565	1.585		1.5745	1.5745	1.5742	1.5755	1.573
AI								

W/O:		WORK ORDER CHANGES					
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Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:	FK.	Date:	12/02/14
Audited by:		Date:	12-02-15
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 X	7 X	8 X	9 X	10 X
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.121	.121	.121	.122	.122
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.325	1.325	1.325	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.1353	1.135	1.136	1.1355	1.1365
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145	.140	.140	.140	.140	.140	.140
P	0.240	0.260		.251	.251	.250	.251	.251
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.117	.117	.117	.117	.117
AE	0.235	0.240		.236	.236	.236	.236	.236
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.109	.109	.109	.111	.111
AH	1.565	1.585		1.5742	1.575	1.5744	1.5737	1.5745
AI								

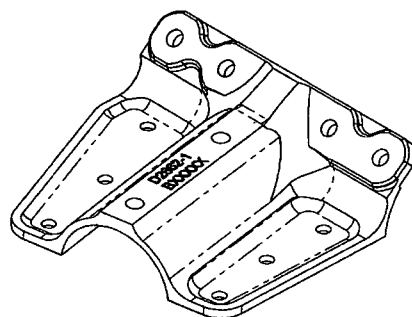
DART AEROSPACE LTD		Work Order:	79209
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

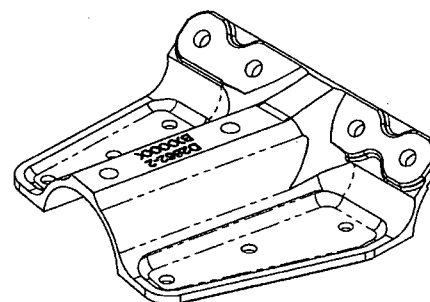
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: FK	Date: 12/02/14
Audited by:	Date: 12-02-15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16
JW

UNCLAS

SUBMIT

WILL

NO

NO - 79209 M.L.S

12/01/23

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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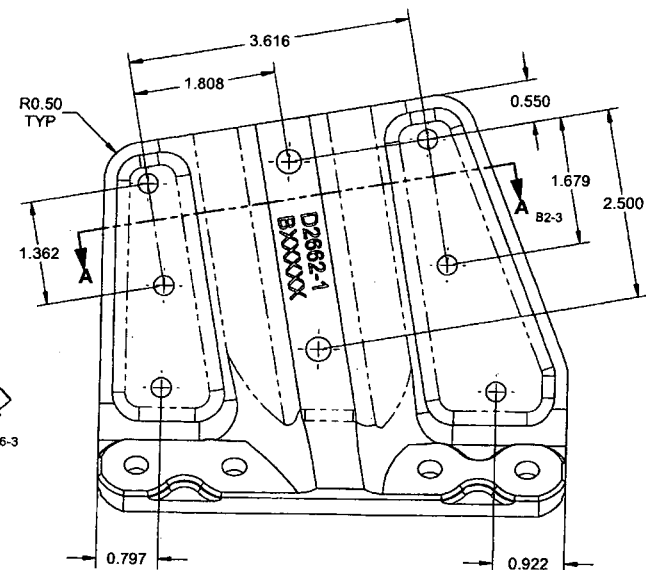
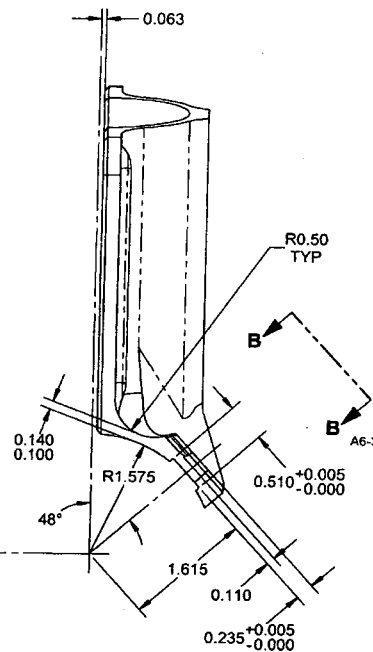
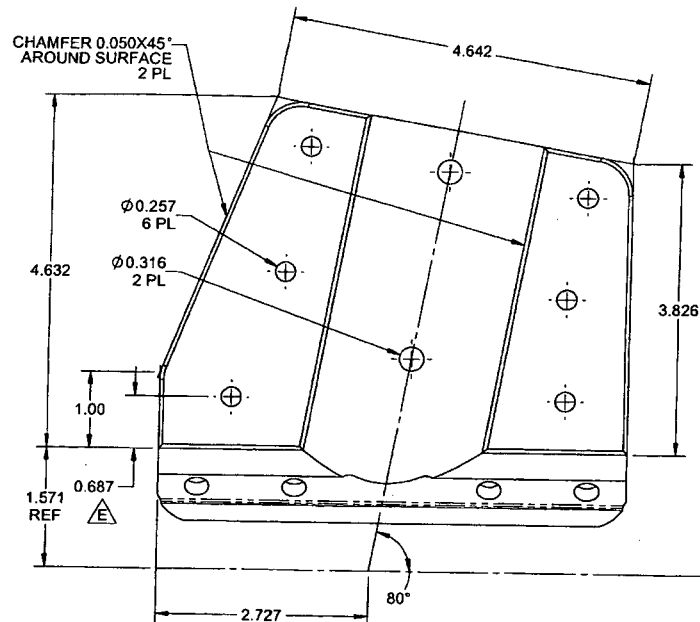
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NOTE: Date & initial all entries

79209



RELEASE
2011-11-16

D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D8101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
2011-11-16



DESIGN	90	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	REV.
DRAWN	90		SHEET 3 OF 3
CHECKED	AS		SCAL
MFG. APPR.			NT
APPROVED			
DE APPR.			
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

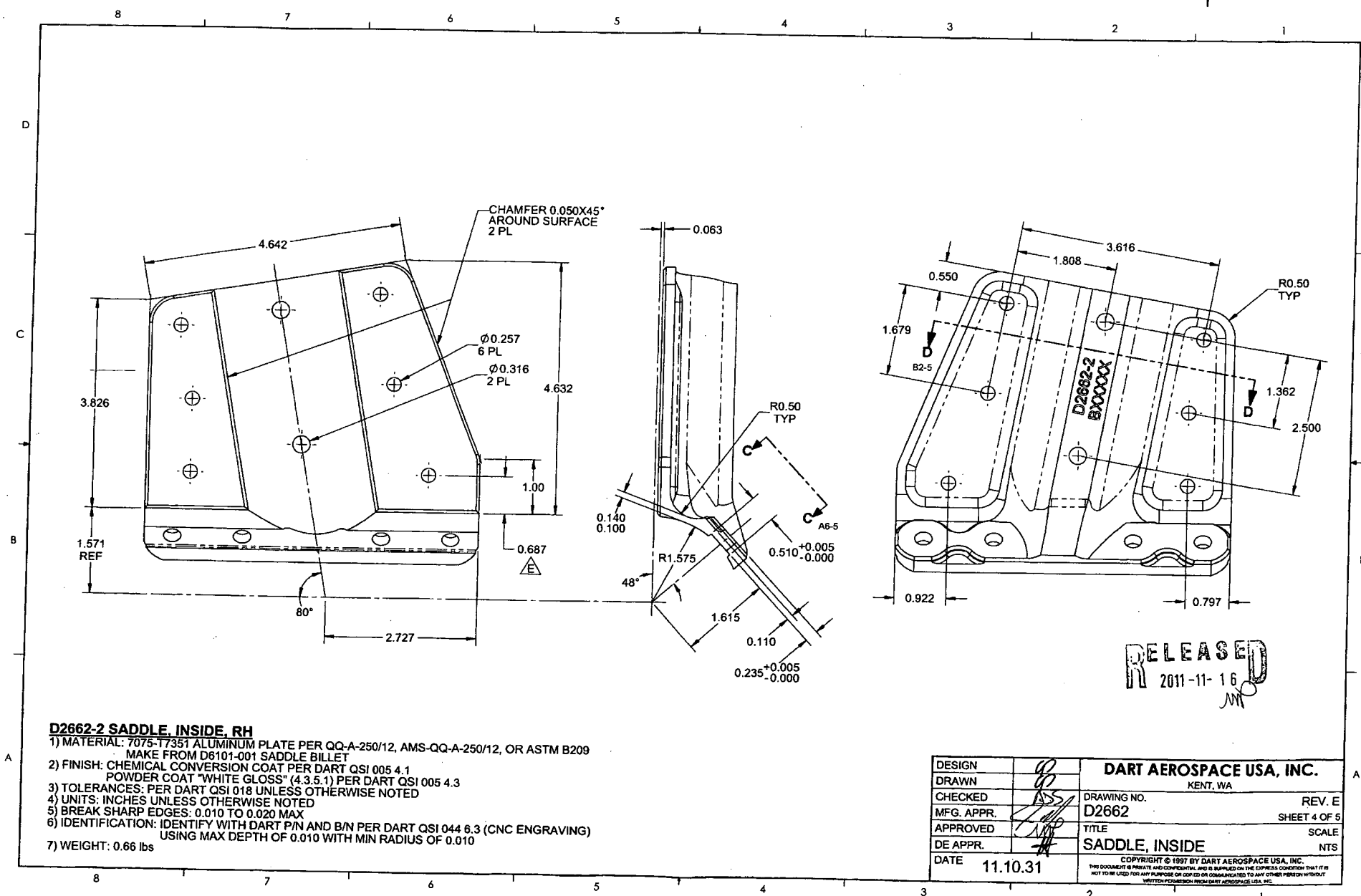
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79205



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

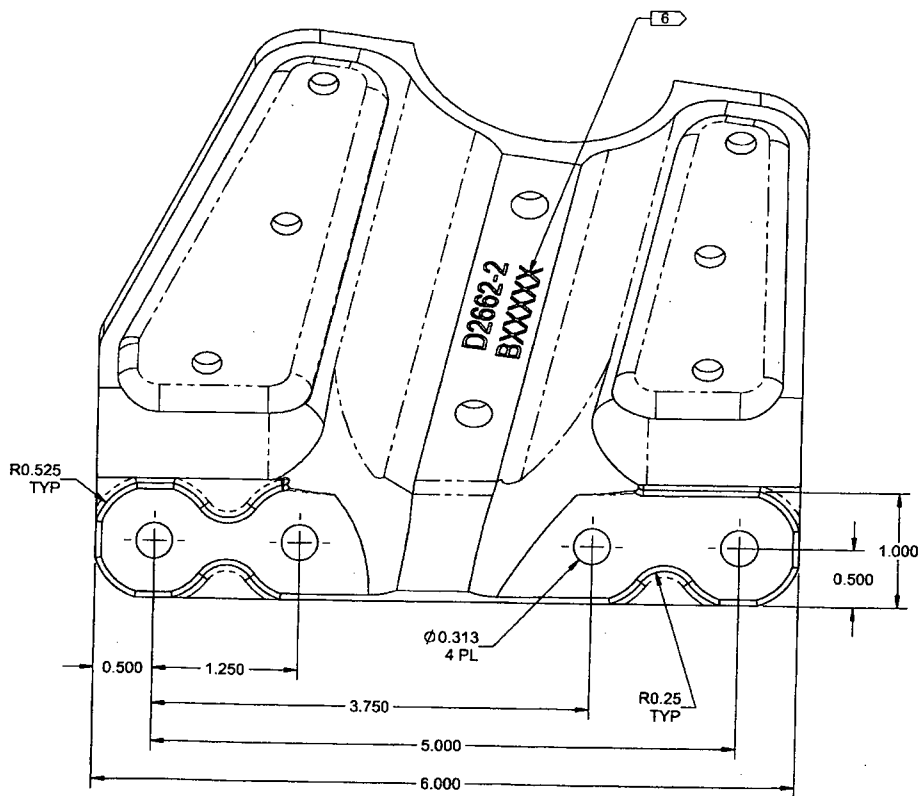
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

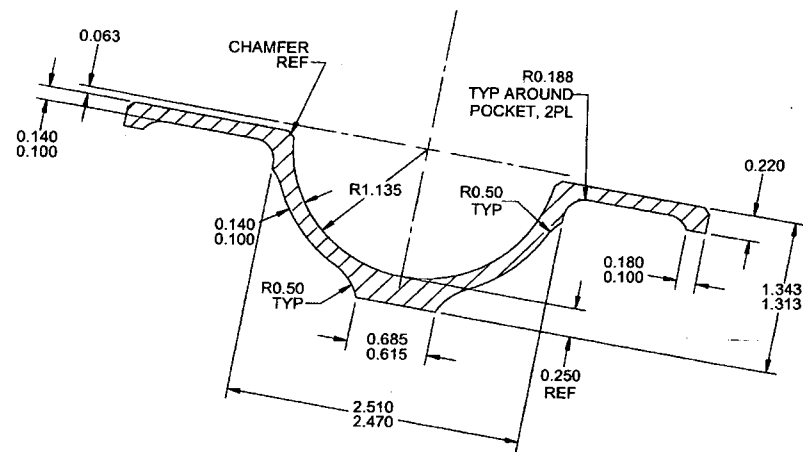
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79205




VIEW D-D
SCALE 1.5X
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries